

Work Order ID 65052 -1

Wednesday, January 05, 2011 4:08:39 PM



Page 1

Item ID: D3953-3

Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date: 1/6/2011 Start Qty: 12.00

Required Date: 1/14/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: MF

QC:

Date: 11-01-05 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3953

C

100



Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: A

DWG REV: SA 11/1/08

DEBURR

QC2- Inspect parts off machine FAI/FAIB

0.00

110



QC

Quality Control

Memo

0.00

SA 11/1/08

2
①

2
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3953-3

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Stud, Lid

Stop



Start Date: 1/6/2011 Start Qty: 12.00



Required Date: 1/14/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

2

130

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

w/o 65202

EF 11/01/18 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18

ME 11-01-18

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Picklist Print

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Page 1

Work Order ID: 65052

Parent Item: D3953-3

Parent Item Name: Gas Spring Stud, Lid



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

48.0000

0.125

1.578947



304 SS Roundbar .750



Handwritten signature and date 1/11/15

Location

Loc Qty

Loc Code

MAT

48

— 116501

48

MAT028

3.68421E-05

113216

3.6842E-05

Handwritten note: .02 ft

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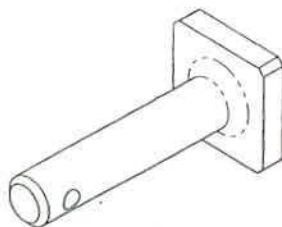
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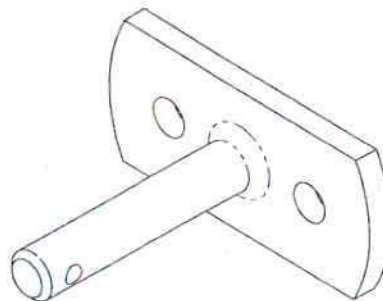
NOTE: Date & initial all entries



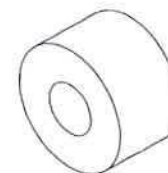
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



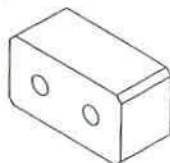
D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



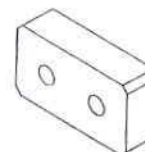
D3953-11 GAS SPRING SPACER



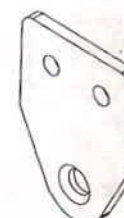
D3953-13 GAS SPRING SPACER
(FULL LID)



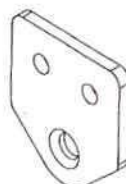
D3953-16 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-02-26

C	PARTS -19 & -21 ADDED (SHT 18-4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); & SYMM WAS & SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADD. PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MINMAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	0507.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		
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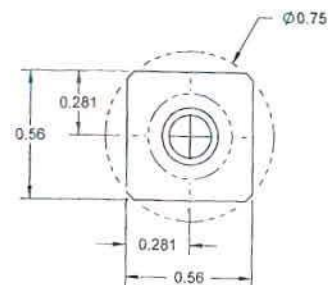
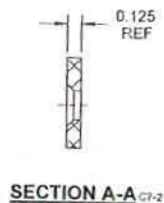
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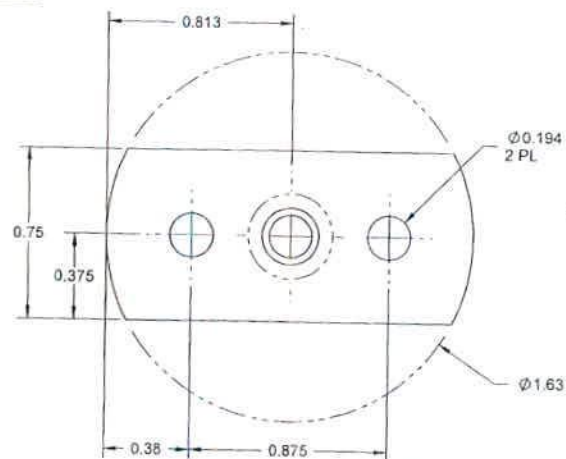
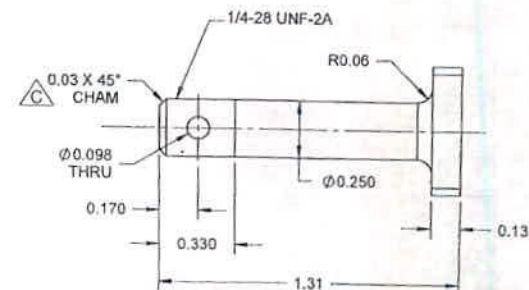
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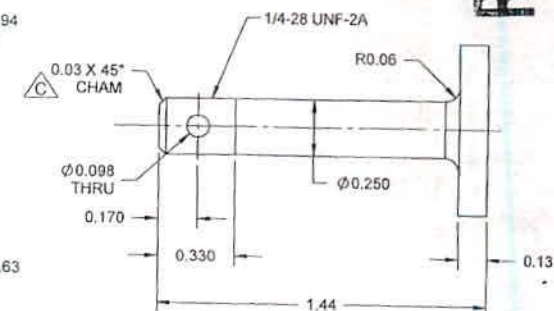
NOTE: Date & initial all entries



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



RELEASED
2010-02-26

- 8: 0.06 lbs

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DRAWN	JPH		SHEET 2 OF 2
CHECKED	JPH		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

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